

Work Order ID 109187

November-13-13 12:50:54 PM

109187

Page 1

Item ID: D119-675-011

Revision ID:

Item Name: Heli-Access-Step™, LH

Start Date: 11/13/13 Start Qty: 2.00

Required Date: 11/14/13 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9647	A

100	DOCUMENT CONTROL	0.00	DAS	27	13 11 14	2			
100									
DC	Memo <i>M.A.</i>	0.00	3-89						
Document Control	Photocopy bluefile & type labels per PPP D119-675-011 CHG005								

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00				2x	DAS	28	13-11-13
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control			DAS	27	13 11 14				
			9-89						

Work Order ID 109187

November-13-13 12:50:54 PM

109187

Page 2

Item ID: D119-675-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™, LH

Start Date: 11/13/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/14/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-675-011
Location: 081152 13/11/15 8

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

13-11-22
13-11-21

Picklist Print

November-13-13 12:50:52 PM

Page 1

Work Order ID: 109187

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step™, LH

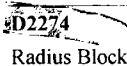

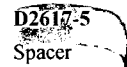
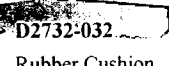
Start Date: 11/13/13

Required Date: 11/14/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01
IPP RevE change at rev.b as per ECN1107 DD verified by: IPP REV:F 13.09.03 chg005 /
DSI9647 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D2274 Radius Block		Manufactured	No			110	Each	308.0000	8	16	DAS 28 9-89	13-11-13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		2							
				86855		2							
				ST008		306							
				102156		6							
				106191		300							
 D2617-3 Bushing		Manufactured	No			110	Each	38.0000	4	8	DAS 28 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		10							
				27991		10							
				ST013		28							
				106147		4							
				107905		20							
				86394		4							
 D2617-5 Spacer		Manufactured	No			110	Each	47.0000	4	8	DAS 28 9-89		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		10							
				31756		10							
				ST013		37							
				107480		14							
				107593		21							
				86395		2							
 D2732-032 Rubber Cushion		Manufactured	No			110	Each	0.0000	8	16	DAS 28 9-89	B107346	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					

Picklist Print

November-13-13 12:50:53 PM

Page 2

Work Order ID: 109187

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step™, LH

Start Date: 11/13/13

Required Date: 11/14/13

Start Qty: 2.00

Required Qty: 2.00

D3041-1 Clamp	Manufactured	No			110	Each	32.0000	8	DAS 28 9-89	13-11-13
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
DAS 27 9-89 2X			ST462	32						
			84000	1						
			86255	31						
D3041-3 Clamp	Manufactured	No			110	Each	24.0000	4	DAS 28 9-89	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
DAS 27 9-89 2X			ST462	24						
			51114	8						
			84001	16						
D3041-5 Clamp	Manufactured	No			110	Each	19.0000	8	DAS 28 9-89	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
DAS 27 9-89 2X			ST466	19						
			106485	19						
D3041-7 Clamp	Manufactured	No			110	Each	35.0000	4	DAS 28 9-89	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
DAS 27 9-89 2X			ST466	35						
				35						
D3043-041 Step Weldment LH	Manufactured	No			110	Each	0.0000	2	DAS 6 9-89	109014
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
DAS 27 9-89 2X			ST466	35						
			106487	35						

Use 109014
From RA 111633

November-13-13 12:50:53 PM

Shop Packet Print

Page 2

Picklist Print

November-13-13 12:50:53 PM

Page 3

Work Order ID: 109187

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step™, LH

Start Date: 11/13/13

Required Date: 11/14/13

Start Qty: 2.00

Required Qty: 2.00

AN4-15A
Bolt

Purchased No

110 Each 276.0000 4 8

DAS
28 13-11-13
9-89

Location

Loc Qty

Loc Code

FP001 4
122141 4
GA 100
120449 100
ST357 9
123900 1
m125709 2
m125750 6
ST514 163
123525 13
m126105 150

DAS
6
9-89

DAS
27
9-89

AN4-16A
Bolt

Purchased No

110 Each 273.0000 8 16

DAS
28
9-89

Location

Loc Qty

Loc Code

FG 5
121541 5
ST357 108
124215 8
M127432 100
ST514 160
125427 113
M126073 47

DAS
8
9-89

DAS
27
9-89

16x

November-13-13 12:50:53 PM

Shop Packet Print

Page 3

Picklist Print

November-13-13 12:50:53 PM

Page 4

Work Order ID: 109187

Parent Item: D119-675-011

Parent Item Name: Heli-Access-Step™, LH

Start Date: 11/13/13

Required Date: 11/14/13

Start Qty: 2.00

Required Qty: 2.00

~~NAS1149D0463J~~

Purchased No

110 Each 2,119.0000

24

DAS
28
9-89

13-11-13

WASHER

Location

Loc Qty

Loc Code

FP001	2
122441	2
ST007	24
121912	24
ST294	1527
119097	1
124198	35
124778	83
M127255	1408
ST510a	566
M126221	566

DAS
27
9-89

12
DAS
6
9-89

~~MS2104214~~

Purchased No

110 Each 5,731.0000

24

DAS
28
9-89

Locknut

Location

Loc Qty

Loc Code

FP001	50
122452	38
8182	12
ST314	9
m125708	9
st507	33
m126073	33
ST509	5308
m123376	2000
m126275	1332
m127255	1976
ST510a	173
m126333	173
ST518	158
124231	158

1
21
9-89

12
DAS
6
9-89

24x

November-13-13 12:50:53 PM

Shop Packet Print

Page 4

CONFIDENTIAL ONLY

DAS
27
9-89

4.0 WEIGHT AND BALANCE:

Use the following Weight and Balance for D119-675-011/-012 @ CHG 005 or later.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011	11.8 lb	-32.4 in	-382 in-lb	121.3 in	1431 in-lb
Heli-Access-Step™, LH	5.4 kg	-1.28 m	-6.9 m-kg	3.08 m	16.6 m-kg
D119-675-012	11.8 lb	+32.4 in	+382 in-lb	121.3 in	1431 in-lb
Heli-Access-Step™, RH	5.4 kg	+1.28 m	+6.9 m-kg	3.08 m	16.6 m-kg

5.0 PARTS LISTS:

QTY -011	Part Number	Description
X	DSI 9647-011	CLAMP REPLACEMENT KIT
4	D2732-032	RUBBER CUSHION
4	D3041-5	CLAMP
2	D3041-7	CLAMP
8	AN4-16A	BOLT
8	AN960JD416	WASHER
8	MS21042L4	BOLT

Use the following Parts List for D119-675-011/-012 @ CHG 005 or later.

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	HELI-ACCESS-STEP™, LH
	X	D119-675-012	HELI-ACCESS-STEP™, RH
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
4	4	D2617-5	BUSHING
8	8	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3041-5	CLAMP
2	2	D3041-7	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
8	8	AN4-16A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

DESIGN	AJS	DART AEROSPACE USA, INC KENT, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9647	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CLAMP REPLACEMENT	NTS
DATE	13.04.04	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

Work Order ID 109187

November-13-13 12:50:54 PM

109187

Page 1

Item ID: D119-675-011

Accept

Revision ID:

N900040100Setup Start ***NS1***

Item Name: Heli-Access-Step™, LH

Stop ***NS2***

Start Date: 11/13/13 Start Qty: 2.00

2

Required Date: 11/14/13 Req'd Qty: 2.00

2

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI9647	A
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100

100

DC

Document Control

DOCUMENT CONTROL

0.00

Memo



0.00

Photocopy bluefile & type labels per PPP D119-675-011 CHG005

ms 13-11-14
(2)

110

110

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

2x DAS 28 13-11-13

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00